DART AEROSPACE LTD	Work Order:	39952
Description: LONG T-NANDLE ASSY	Part Number:	B67-43001-51
Dwg: B67. 43009 Sheet 13	Qty:	1:
5.13. 1564: 4700: Meet 10		Page of

			D. 1	Deta	Qty
Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler		BOLOY	
2	GA	CUT BG7-47001-87 A> PER DUG GT TO 107950 HATL: 61:00" =0 × 0.065" NALL, GOG1-TC AL bodeh: M107950	201	03-01-01	3
3	GA	CUT 1367 - 43001-91 AS PER DWG (M18/4) MATL: 01.00 OD x 0.25 WALL, GOGI-TG AL best M18/4/	+ /h	03-01-0	3
4	CA	MINNA!	7 /2	07-07-0	10
54	1110	WELD PARTS A PER DWG. Workenget.			:
55	QC 5/5	: Evered Level 9/ Level 5			
6	VP -	CHEM. CONVERSION (ALDOINE)			
+	GA	PICK B67-43001-89 AND INSTALL PART ON 867-43001-87 butch:			1.
8	GA	DRUC #30 HOLE THRU BOTH B67-43001-87/-	ટ્ય		t,
9 A	GA	WSERT 81/8" = 11/8" SPENS SCOTTED DW W # 30 HOLE			1
		(M17850) + GRWD PW FLUSH TO TUBING			
95	QUS	# Multe Inspect level 5			
10	188	POWDER CONT GREEN SANDTEX. PRQSI COS			
IC	QC3	Inspect Level 3			
12	5T	Identify & Stock			
13	DC	Clase W/o cost/part			-
		Level 21			
					ļ
		PRELIMINARY ISSUE			
		I TETIMINAVILLIOONE			

-	Rev	Date	Change	Revised By	Approved
İ					12

Date: User:

Monday, 28/07/2008 3:38:57 PM

Linda Lacelle

Process Sheet

Customer

CU-DAR001 Dart Helicopters S€rvices

Drawing Name: LONG T-HANDLE ASSEMBLY

Job Number: 40770

Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 101

mx 08-08-20

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

1 4



MF 08-08-26

Date: Monday, 28/07/2008 3:38:57 PM User: Linda Lacelle **Process Sheet** Drawing Name: LONG T-HANDLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 40770 Part Number: PB674300151 Job Number: Seq. #: Machine Or Operation: Description: 6.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 7.0 PB674300189 Clevis Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) 240107 8.0 SPRING SLOTTED PIN Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) SPRING SLOTTED PIN batch: M11 850 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin INSPECT WORK TO CURRENT STEP 10.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 11.0% 02316 Comment: POWDER COATING Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-0

Dart Aerospace Ltd. Monday. 28/07/2008 3:38:57 PM Date: User: Lind# Lacelle **Process Sheet** : CU-DAR001 Dart Helicopters Services : LONG T-HANDLE ASSEMBLY Customer **Drawing Name** Job Number : 40770 Estimate Number : 13522 P.O. Number Part Number : PB674300151 : 28/07/2008 S.O. No. : : B6743001 P.13 This Issue **Drawing Number** : NC Prsht Rev. **Project Number** : N/A . : B1 First Issue : 11 : SMALL /MED FAB Type **Drawing Revision Previous Run** Material Qty: Due Date : 04/08/2008 Written By Checked & Approved By Comment : Est Rev:A 08-07-25 new issue DD verified by:ec See attachment **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** PB674300187 1.0 Tube Arm Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Tube Arm 2.0 Comment: Qty.: 1:0000 Each(s)/Unit Total: 5.0000 Each(s) Tube Handle batch: N PB674300193 3.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Tube End Cap R-01-29 40076 batch: LARGE FABRICATION RESOURCE 1 4.0

Comment: LARGE FABRICATION RESOURCE 1

- 1- drill #40 hole in center of -91 before welding -93 caps, to let air out
- 2- weld -93 to -91 as per dwg
- 3- grind weld flush
- 4- assemble -87 under the pilot hole in -91 and weld as per dwg

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



Page 1

Each